Work Order ID 95381

95381

January-09-13 11:55:53 AM

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle

Start Date: 2/05/13 **Start Qty:** 40.00 *40* **Cust Item ID:**
Required Date: 2/15/13 **Req'd Qty:** 40.00 *40* **Customer:**
Reference:

Approvals: **Process Plan:** MLJ **Date:** 13-01-10 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3500	Revision Nbr: C								
100	HAAS CNC VERTICAL MACHINING #1	0.00	ok 13/03/07			40	ϕ		DAS 08 9-89
100			D.a 13/03/09						
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program Batch No: 9538 Double check by: _____ 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step No 2 per Folio FA641and inspect per attached Dimension Sheets3-Machine Step No 3 per Folio FA641 and inspect p								
110	QC2- Inspect parts off machine FAI/FAIB	0.00	ok 13/03/07			40	ϕ		DAS 08 9-89
110			D.a 13/03/09						
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120			13-3-12			40	ϕ		DAS 13 2-89
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 95381

January-09-13 11:55:53 AM

95381

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle

Start Date: 2/05/13 **Start Qty:** 40.00 *40*
Required Date: 2/15/13 **Req'd Qty:** 40.00 *40*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date.** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				40		13-3-13	
130 HandFinish Hand Finishing	Memo	0.00							
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				40x		M-L 13/03/18	
140 Powdercoat Powder Coating	Memo START TIME: 9:30 FINISH TIME: 9:30 OVEN TEMPERATURE: 320°F	0.00							
150	QC3- Inspect Part Finish	0.00				40x		M 13/03/18	
150 QC Quality Control	Memo	0.00							

WL24245

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 95381

January-09-13 11:55:53 AM

95381

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle

Start Date: 2/05/13 **Start Qty:** 40.00 *40*
Required Date: 2/15/13 **Req'd Qty:** 40.00 *40*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:_____	0.00							
160 Packaging Packaging	Memo Substitute S/N 37A	0.00					43/3/20 (40)		
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	Memo	0.00					MLJ 13-03-20		

MLJ 13-03-20

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Broken/Damaged
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- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

January-09-13 11:55:53 AM

Work Order ID: 95381
Parent Item: D3500-1
Parent Item Name: Saddle

Start Date: 2/05/13 **Required Date:** 2/15/13
Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 Saddle Billet		Manufactured	No			100	Each	108.0000	1	**40**			

Location	Loc Qty	Loc Code	
MAT043	8		
60713	8		
MAT045	50		
90316	50		
MAT046	50		
87453	38		
90085	12		

B95105X 40 ok 13/03/07

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
Large Fab	☐	Composite	☐	Supplier	☐

Engineering	☐									
Quality	☐									
Other	☐									
	☐									

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Cut Too Short
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- ☐ Grain
- ☐ Hardware
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- ☐ Out of Sequence
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- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.586	1.587	1.587		
J	0.240	0.260		.247	.247	.247	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.549	.549	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.045	.045	.045	.045		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.1345	1.133	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.257	.257	.256		
AE	1.810	1.830		1.821	1.820	1.820	1.820		
AF	0.240	0.260		.255	.254	.255	.254		
AG	0.140	0.160		.155	.155	.156	.156		
AH	0.140	0.160		.157	.156	.157	.156		
AI	0.140	0.160		.159	.159	.160	.159		
Accept/Reject									

Measured by:	DAS 14
Date:	13/03/07 89

Audited by	DAS 13 89
Date:	13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.588	1.588	1.588		
J	0.240	0.260		.246	.247	.247	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.047	.047	.047	.046		
Y	0.100	0.120		.105	.110	.110	.110		
AA	R1.125	R1.145		1.134	1.1345	1.1345	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.256	.256	.256		
AE	1.810	1.830		1.820	1.821	1.820	1.820		
AF	0.240	0.260		.255	.255	.255	.255		
AG	0.140	0.160		.156	.156	.156	.156		
AH	0.140	0.160		.157	.157	.159	.156		
AI	0.140	0.160		.157	.157	.159	.159		
Accept/Reject									

Measured by:	DAS 14
Date:	13/03/02

Audited by	DAS 13
Date:	13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.586	1.587	1.587		
J	0.240	0.260		.247	.246	.247	.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.060		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.549	.549	.500		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.048	.046	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.134	1.133	1.133	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.256	.256	.256		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.255	.255	.255	.255		
AG	0.140	0.160		.155	.155	.155	.154		
AH	0.140	0.160		.158	.157	.158	.156		
AI	0.140	0.160		.159	.159	.159	.157		
Accept/Reject									

Measured by:	DAS 14
Date:	13/03/08 -89

Audited by	DAS 13
Date:	-89 13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	~~14~~	~~15~~	~~16~~	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.588		
J	0.240	0.260		.247	.247	.247	.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.547	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.047	.047	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.134	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.256	.256	.256	.257		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.255	.255	.255	.255		
AG	0.140	0.160		.155	.155	.156	.155		
AH	0.140	0.160		.157	.156	.156	.156		
AI	0.140	0.160		.159	.159	.157	.157		
Accept/Reject				DAS 14 9-89			DAS 13 9-89		

Measured by:	[signature]
Date:	13/03/08

Audited by	
Date:	13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	95381
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.588	1.588	1.588		
J	0.240	0.260		.247	0.247	0.247	0.247		
K	0.490	0.510		.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.570	6.570	6.570	6.570		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	0.557	0.557	0.557		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	0.050	0.050	0.050		
Y	0.100	0.120		.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.135	1.1345	1.1345	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.256	0.258	0.258	0.258		
AE	1.810	1.830		1.820	1.821	1.821	1.823		
AF	0.240	0.260		.256	0.254	0.254	0.255		
AG	0.140	0.160		.155	0.155	0.153	0.153		
AH	0.140	0.160		.156	0.160	0.160	0.158		
AI	0.140	0.160		.159	0.160	0.160	0.159		
Accept/Reject									

Measured by:	DAS 14 09-89	D.A DAS 08 09-89	
Date:	13/03/08	13/03/09	

Audited by	DAS 13 09-89	
Date:		13-3-13

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.5875	1.588	1.588		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.135	1.1345	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.257	0.257	0.257	0.257		
AE	1.810	1.830		1.823	1.823	1.823	1.823		
AF	0.240	0.260		0.255	0.254	0.255	0.255		
AG	0.140	0.160		0.157	0.155	0.154	0.155		
AH	0.140	0.160		0.159	0.160	0.160	0.160		
AI	0.140	0.160		0.159	0.159	0.160	0.159		
Accept/Reject							DAS 13/03/09		

Measured by:	D.A DAS	Audited by	13
Date:	13/03/09 08/03/09	Date:	13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#25	26	#27	#28	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.5875	1.588	1.5875		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.517	6.517	6.517	6.517		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.135	1.1345	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.257	0.257	0.257	0.257		
AE	1.810	1.830		1.823	1.823	1.823	1.823		
AF	0.240	0.260		0.254	0.254	0.255	0.254		
AG	0.140	0.160		0.155	0.155	0.155	0.156		
AH	0.140	0.160		0.159	0.157	0.160	0.158		
AI	0.140	0.160		0.160	0.158	0.159	0.159		
Accept/Reject									

Measured by:	b.e DAS
Date:	13/03/10 08-03

Audited by	DAS 13
Date:	13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/29	2/30	3/	4/32	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.5875	1.5875	1.5875		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1345	1.135	1.135	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.257	0.257	0.257	0.257		
AE	1.810	1.830		1.823	1.823	1.823	1.823		
AF	0.240	0.260		0.256	0.255	0.255	0.255		
AG	0.140	0.160		0.155	0.155	0.155	0.155		
AH	0.140	0.160		0.159	0.159	0.159	0.160		
AI	0.140	0.160		0.159	0.159	0.159	0.159		
Accept/Reject									

Measured by:	D.a	DAS 08	Audited by: DAS 13
Date:	13/03/10		Date: 13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X33	X34	35	X36	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.5875	1.588		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.626	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.135	1.135	1.1345		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.257	0.257	0.257	0.257		
AE	1.810	1.830		1.823	1.823	1.823	1.823		
AF	0.240	0.260		0.254	0.255	0.255	0.255		
AG	0.140	0.160		0.155	0.156	0.155	0.154		
AH	0.140	0.160		0.158	0.158	0.159	0.160		
AI	0.140	0.160		0.158	0.158	0.160	0.159		
Accept/Reject									

Measured by:	DAS DS
Date:	13/03/11

Audited by	DAS 13
Date:	13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	95381
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	37	38	39	40	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.589	1.590		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.626	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.135	1.1345	1.1345		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.257	0.242	0.257	0.257		
AE	1.810	1.830		1.823	1.823	1.823	1.823		
AF	0.240	0.260		0.255	0.254	0.255	0.255		
AG	0.140	0.160		0.155	0.156	0.155	0.156		
AH	0.140	0.160		0.158	0.160	0.159	0.160		
AI	0.140	0.160		0.158	0.160	0.160	0.159		
Accept/Reject							DAS		

Measured by:	DAS
Date:	13/03/11 08

Audited by	13
Date:	13-3-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

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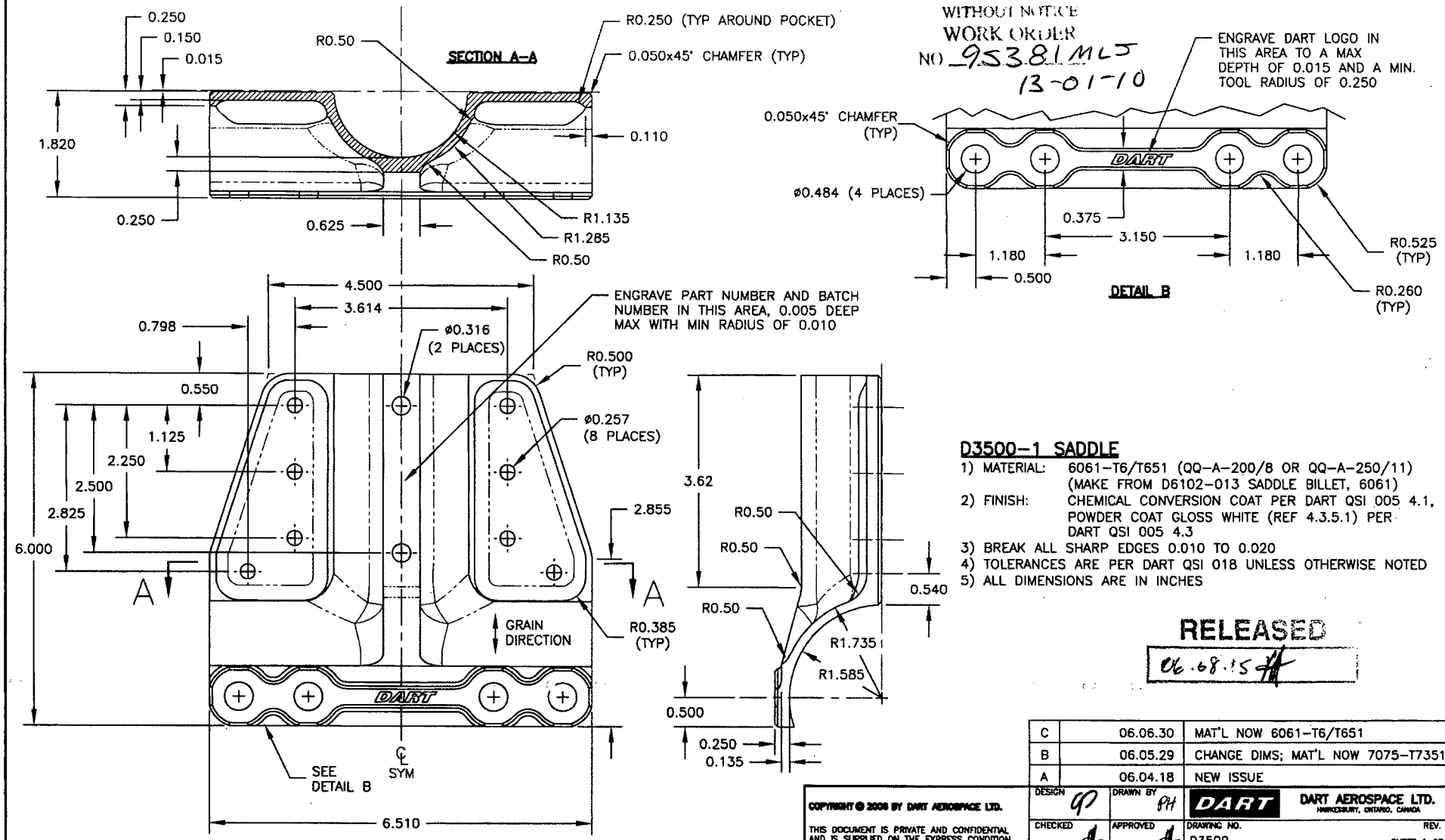
WORK ORDER
NO 95381 MLJ
13-01-10



D3500-1 SADDLE

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

RELEASED
06.08.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD.	
GP	PH	HAVELOCK, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3500	SHEET 1 OF 1
DATE		TITLE	SCALE
06.06.30		SADDLE	2:3